

Work Order ID 83008

Thursday, April 12, 2012 11:17:40 AM

83008

Page 1

Item ID: D3436-043 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Step LH
Start Date: 4/12/2012 Start Qty: 3.00 *3* Cust Item ID:
Required Date: 4/24/2012 Req'd Qty: 3.00 *3* Customer:
Reference:

Approvals: Process Plan: P Date: 12-04-12 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3436	Rev A								

100 0.00
100 Large Fab 3 12-04-17 JBL
Large Fab Memo 0.00
Large Fab Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and
Dwg D3436Dwg Rev: _____ Qty Part Number Description
BatchA/RN/A 4130 Welding Rod M118875 Weld
left step D3436-7 using welding Jig DT

110 0.00
110 BAND SAW 3 12-04-17 JBL
Bandsaw Memo 0.00
Jeaspa Bandsaw 1- Slit part D3436-041 on bandsaw as per Dwg D3436 2-
debur

120 0.00
120 QC9- Inspect visual per QSI004- Fusion Welds 3x JBL
QC Memo 0.00 12-04-18

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83008

83008

Page 2

Thursday, April 12, 2012 11:17:41 AM

Item ID: D3436-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step LH
 Start Date: 4/12/2012 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 4/24/2012 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4								
	START TIME: 11:10								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 11:40								
145	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
145									
HandFinish	Memo	0.00							
Hand Finishing	Wing walk B 20902								

m 121134

3
LH

3X
LH

3
BLD-4-20

M-F
12/04/19

W/O:		WORK ORDER CHANGES					
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Page 3

Quality Control

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Thursday, April 12, 2012 11:17:41 AM

Page 4

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

Memo

PPP 83148

Packaging

0.00

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 12, 2012 11:17:45 AM

Page 1

Work Order ID: 83008

83008

Parent Item: D3436-043

D3436-043

Parent Item Name: Step LH

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP .A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3436-1		Manufactured	No			100	Each	33.0000	1	3			
D3436-1													
Clamp													

Location	Loc Qty	Loc Code
WA024	33	
17679	33	

D3436-3		Manufactured	No			100	Each	4.0000	1	3			
D3436-3													
Left Step													

Location	Loc Qty	Loc Code
WA022	4	
65157	4	

D3436-5		Manufactured	No			100	Each	48.0000	4	12			
D3436-5													
Bushing													

Location	Loc Qty	Loc Code
ST044	44	
46592	20	
82071	24	
WA024	4	
75229	4	

D3436-9		Manufactured	No			100	Each	8.0000	2	6			
D3436-9													
Pad													

Location	Loc Qty	Loc Code
GA	8	
79670	4	
80244	4	

FF
12-04-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

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Work Order ID: 83008

83008

Parent Item: D3436-043

D3436-043

Parent Item Name: Step LH

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 3.00

Required Qty: 3.00

D3436-7

Manufactured No

160

Each

35.0000

1

3

D3436-7

**

12-04-17/BL

Cap

Location

Loc Qty

Loc Code

WA021

35

56836

35

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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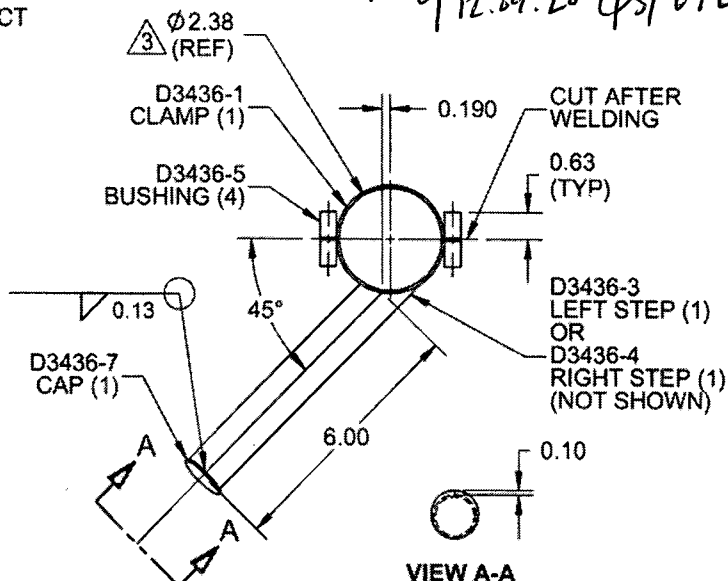
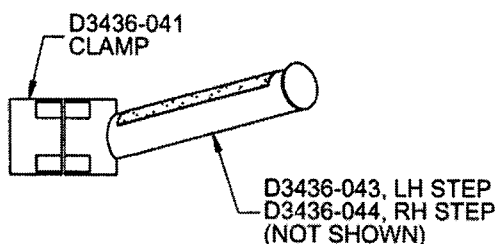
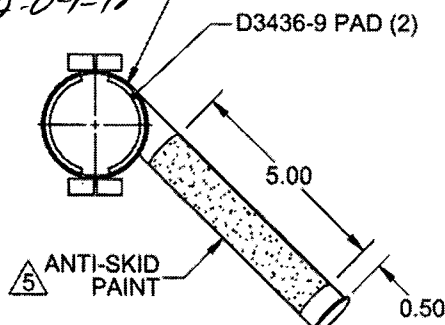


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:4
A	05.04.28	NEW ISSUE	

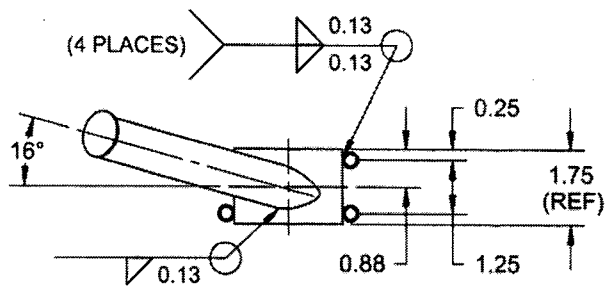
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83008

3M Scotch-Weld
Rubber & adhesive
BOND WITH CONTACT
CEMENT PER
MANUFACTURER'S
SPECIFICATION
(2 PLACES)

OK 05.04.28 QSI 042



VIEW A-A



WELDING

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27 [Signature]

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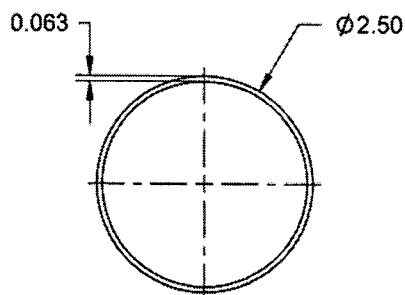
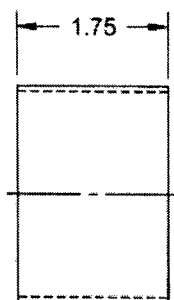
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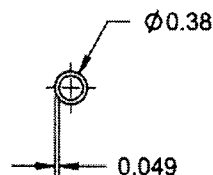
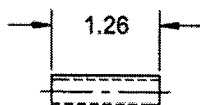
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CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

83008



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 H

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

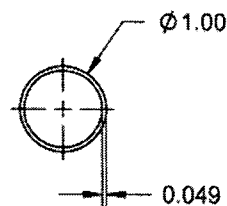
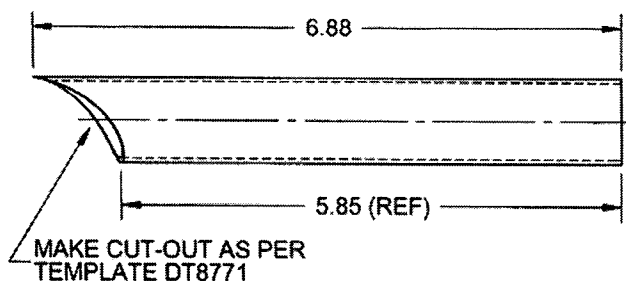
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

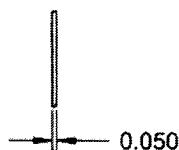
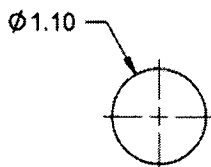
F3008



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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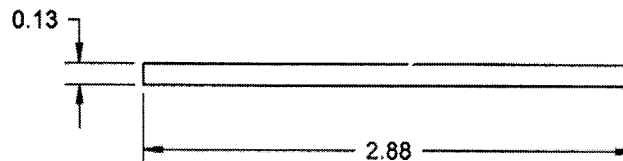
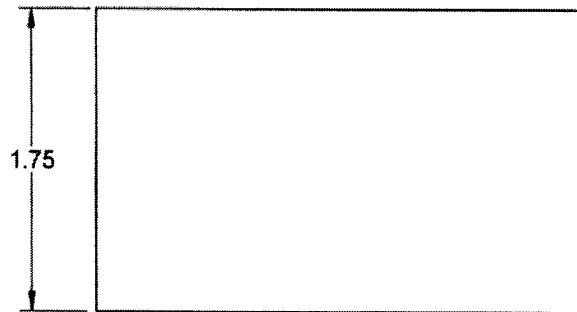
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:1

83008



RELEASED

05.05.27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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